

Date: Monday, 06/10/2008 1:20:58 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG WELDMENT
Job Number	: 42475		
Estimate Number	: 12117		
P.O. Number	:	Part Number	: D3353041
This Issue	: 06/10/2008 S.O. No. :	Drawing Number	: D3353 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 31665	Material	:
Written By	:	Due Date	: 24/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>08.10.06</u>		
Comment	: est rev A 06.01.26 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D335311	Universal Joint
-----	---------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-11	universal joint	B34675✓

PL09.01.09

2.0	D33535	Back Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-5	back plate	B34680✓

PL09.01.09

3.0	D335313	Tubing
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-13	tubing	B34676 → 3✓

B342491 → 2✓

PL09.01.09

4.0	D335317	Support
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-17	support	B30176 → 1✓

B34678 → 3✓

PL09.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 42475

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33533

Right Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-3	right plate	B34879✓

Plc09-01-09

6.0

D33539

Stop Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-9	stop plate	B42494✓

Plc09-01-09

7.0

D33531

Left Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-1	left plate	B37936✓

Plc09-01-09

8.0

D33537

Front Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-7	front plate	334681✓

Plc09-01-09

9.0

D335315

Lock Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-15	lock bracket	B30175✓

Plc09-01-09

W/O:		WORK ORDER CHANGES					
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Drawing Name: LUG WELDMENT

Job Number: 42475

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(X4)

Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3353

PC09-01-09/12 9-1-9

11.0

DO NOT USE

QC9 + QCS

WELD INSPECTION



Comment: WELD INSPECTION

QCS-8 09/01/12 QCS-BE 9-1-12

(4)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

- 1-Mask part as per dwg D3353
- 2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

10:00 AM

OVEN TEMPERATURE:

320 °F

FINISH TIME:

10:20 AM

09-01-12 (4)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/12 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STY90 09/01/12 (4)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/13 (4)

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

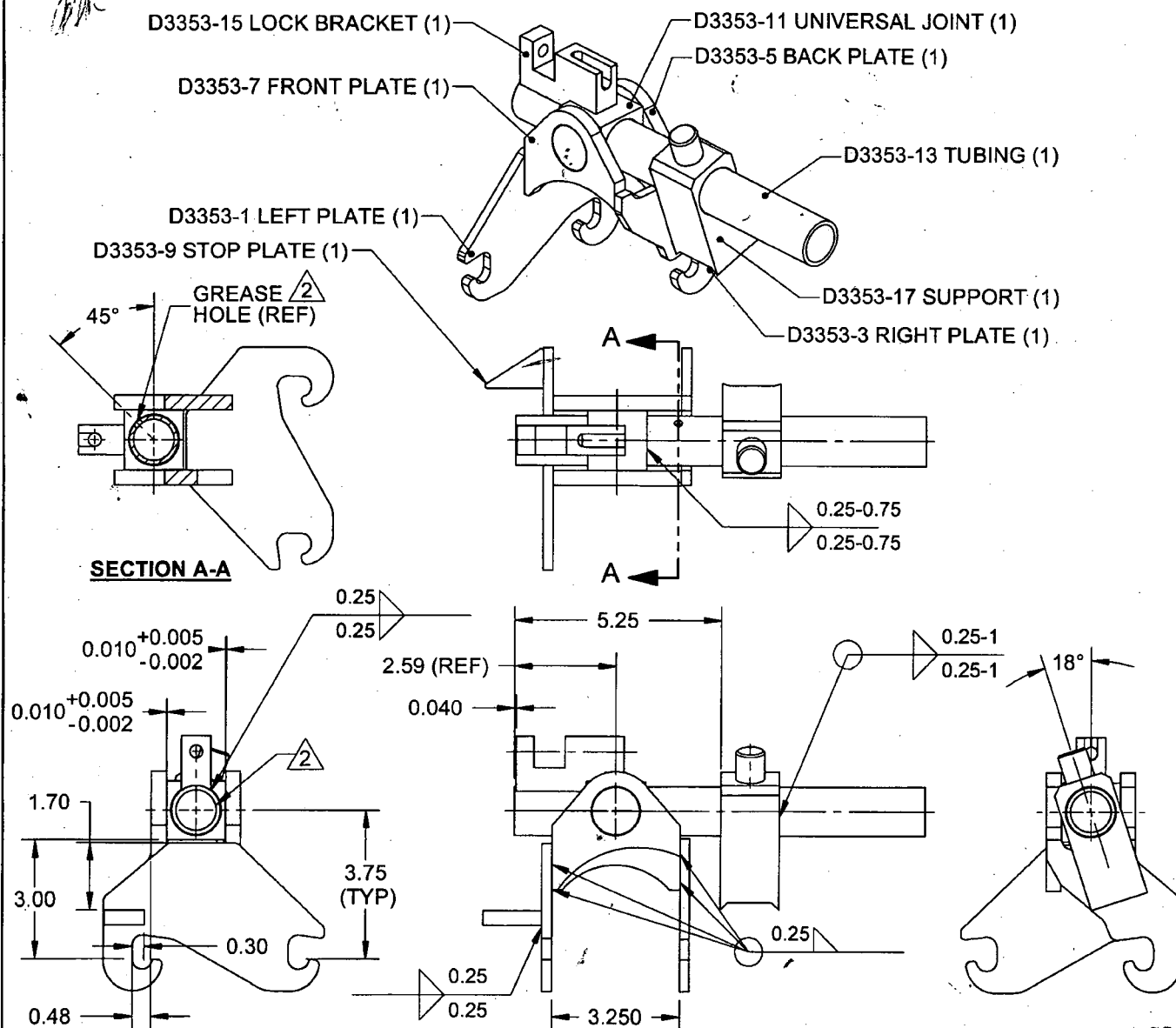
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3353	REV. A SHEET 1 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4
A	04.12.14	NEW ISSUE	

RELEASED
06/30/19**D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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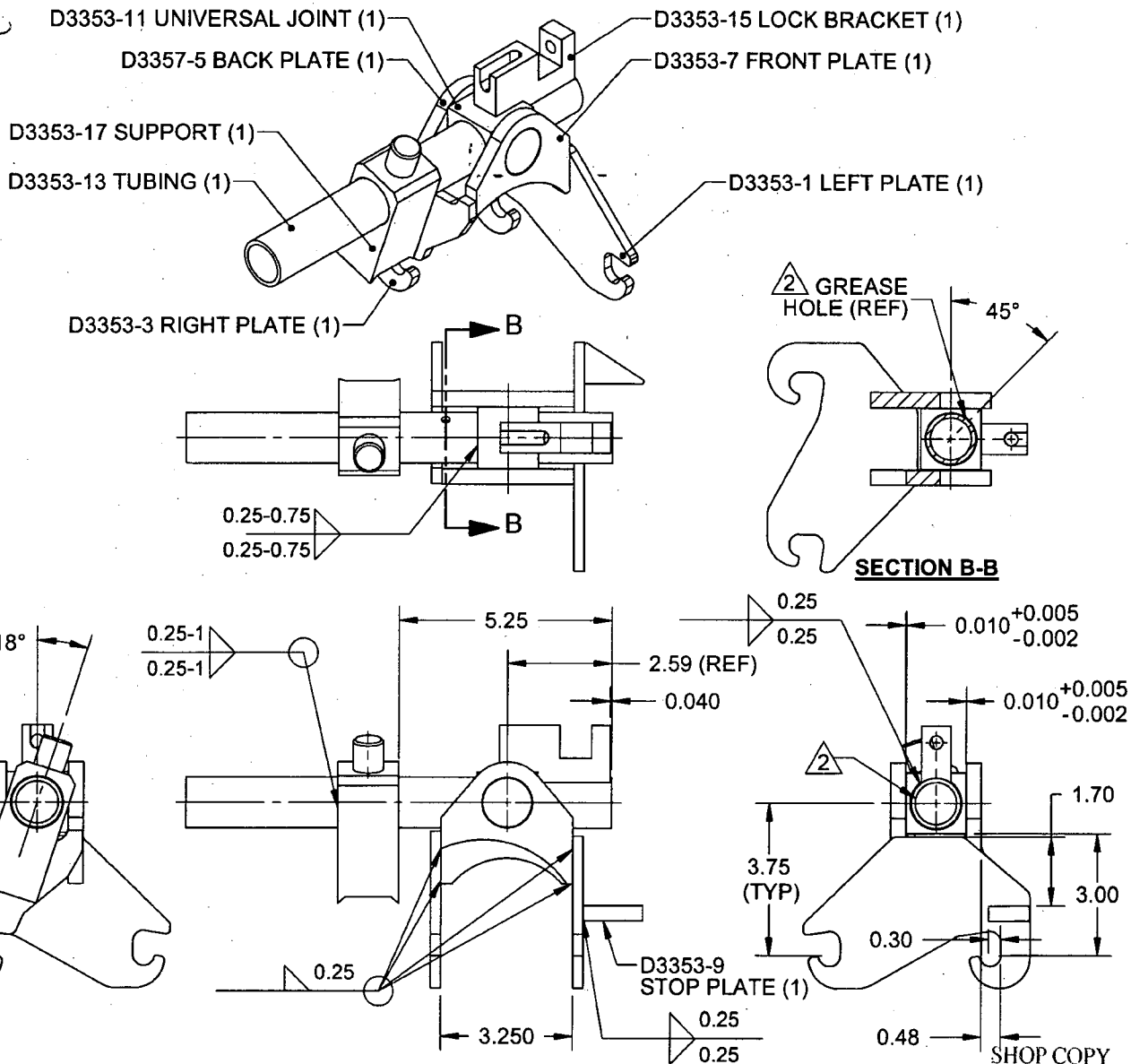
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

RELEASED
06/02/59**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

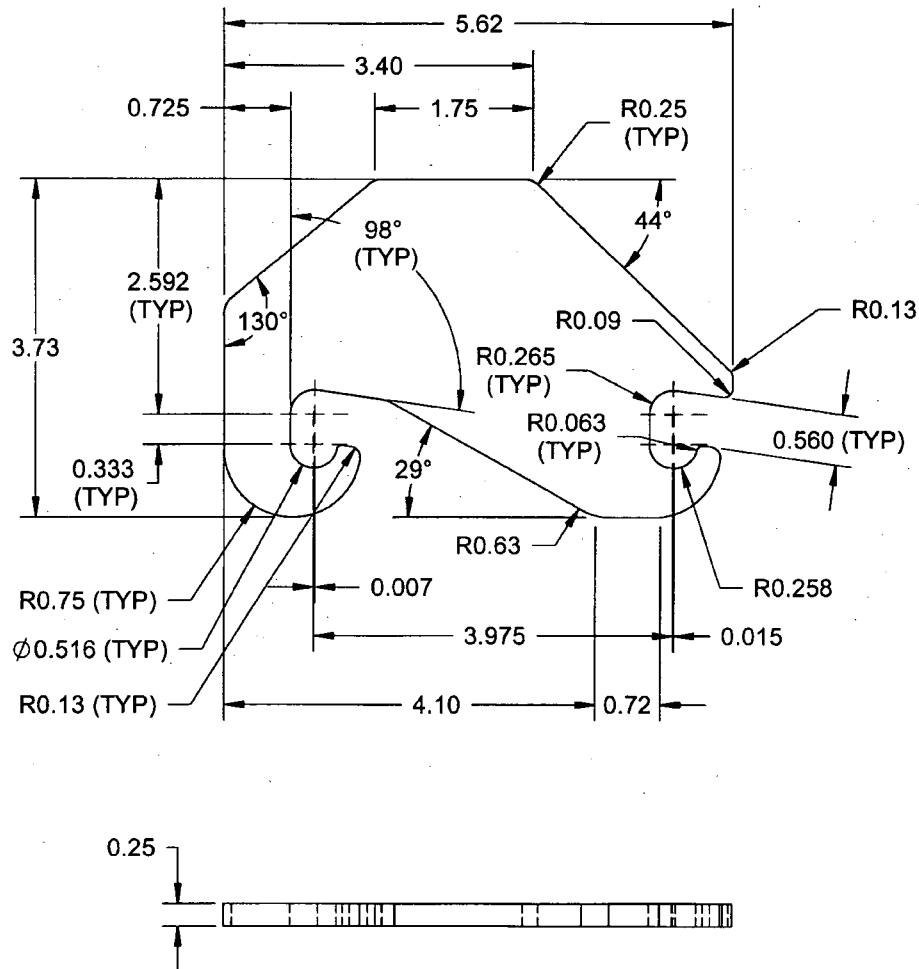
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:2

RELEASED
06/03/64



D3353-1 LEFT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

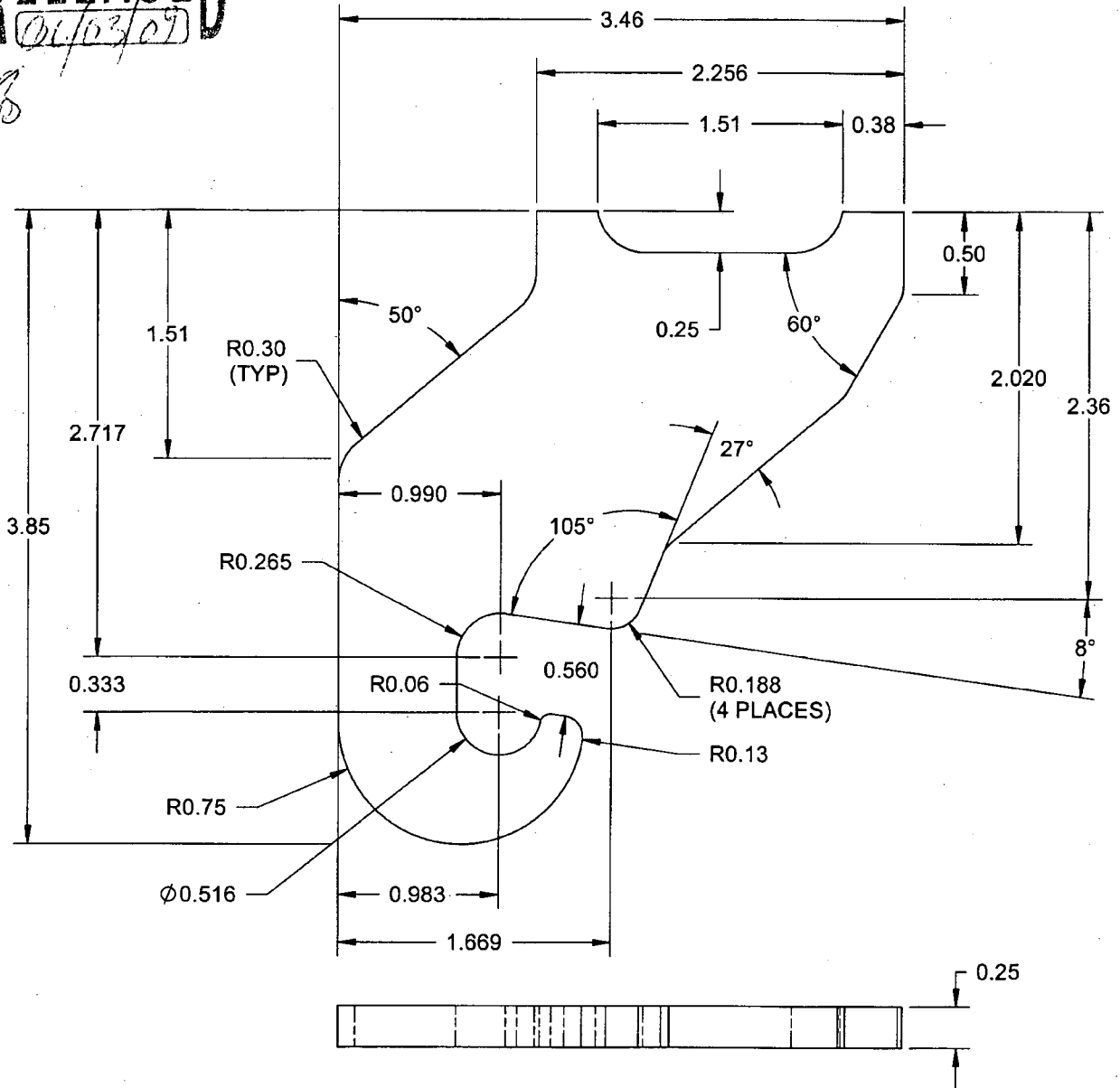
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
01/03/09



D3353-3 RIGHT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

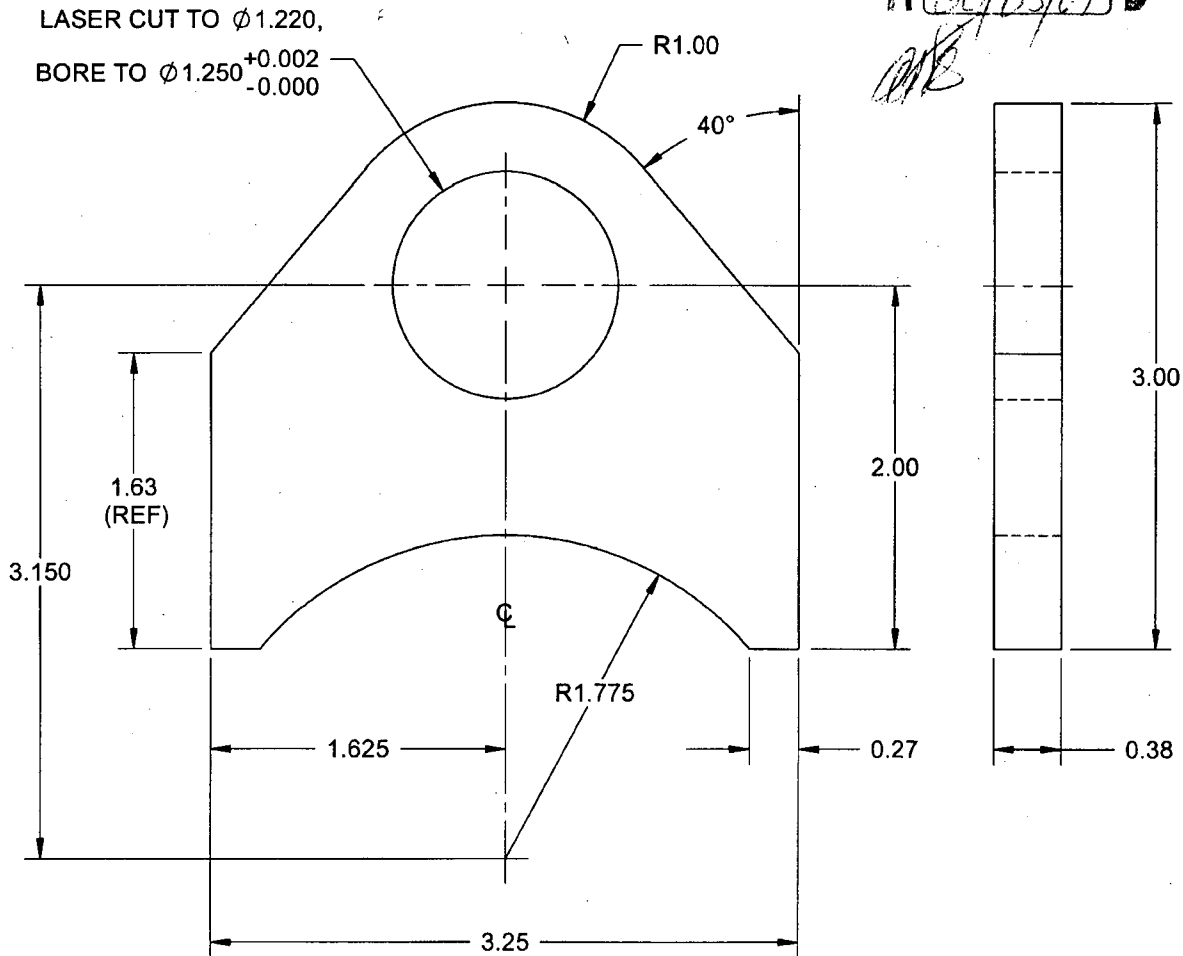
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

**D3353-5 BACK PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

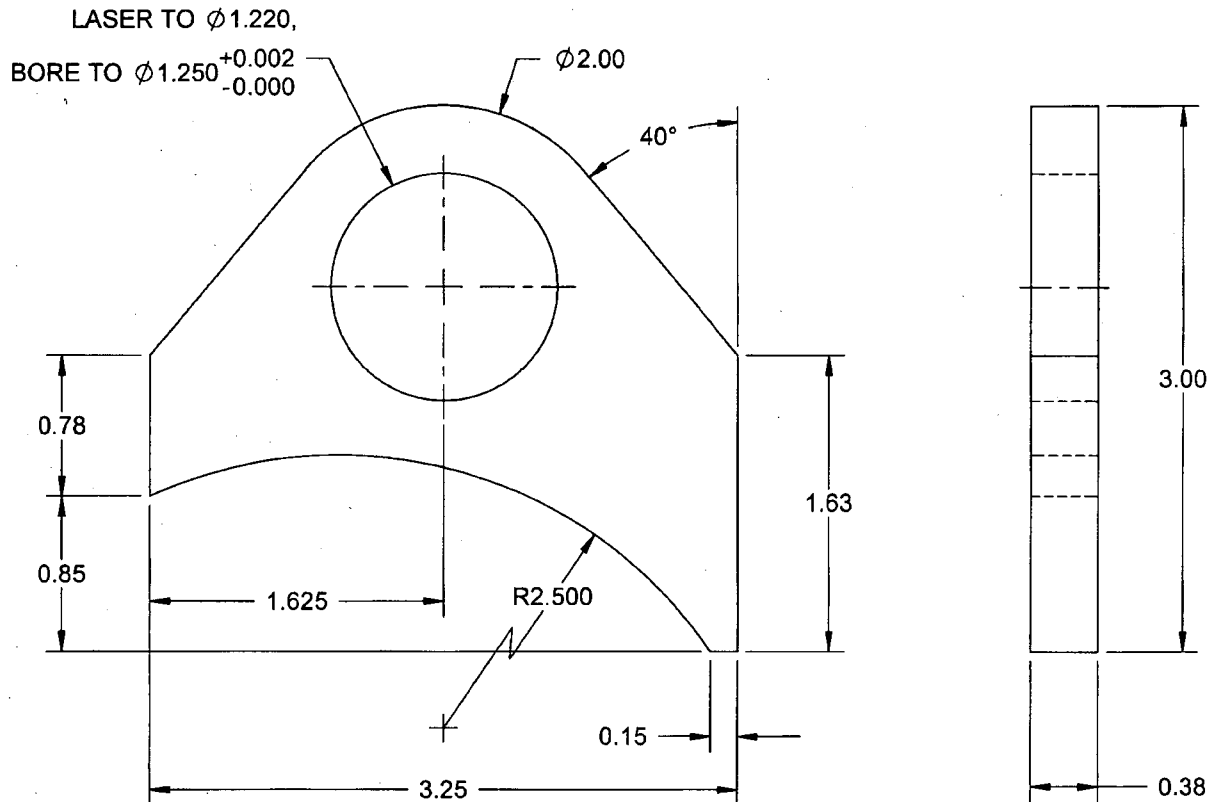
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

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06/03/07



D3353-7 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR
CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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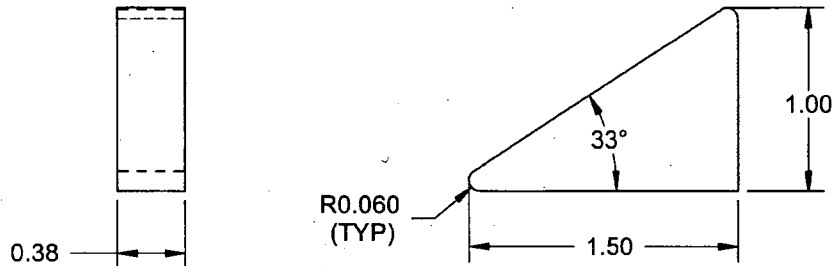
NOTE: Date & initial all entries

DART

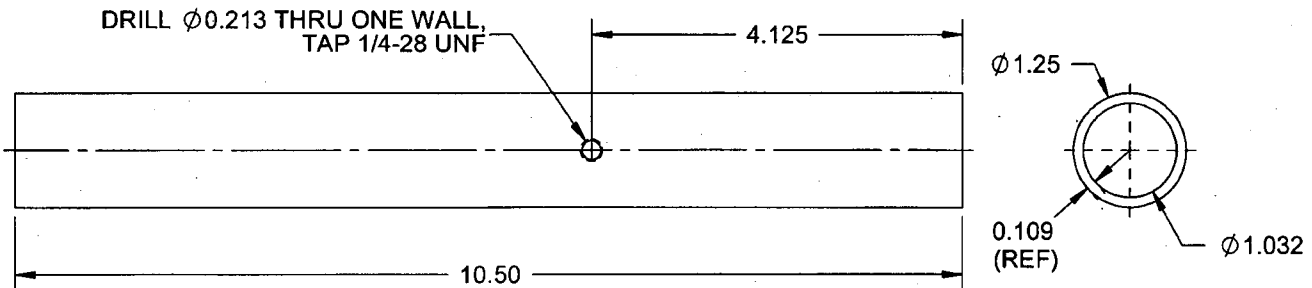
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
3/3/04

[Signature]

**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

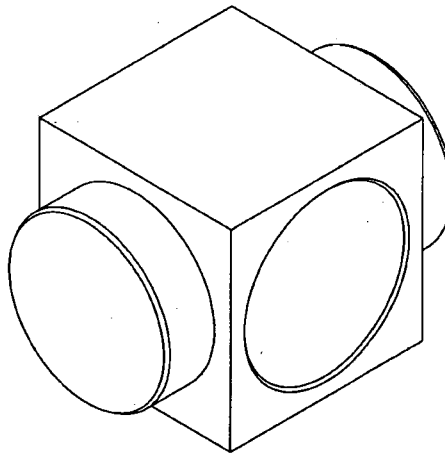
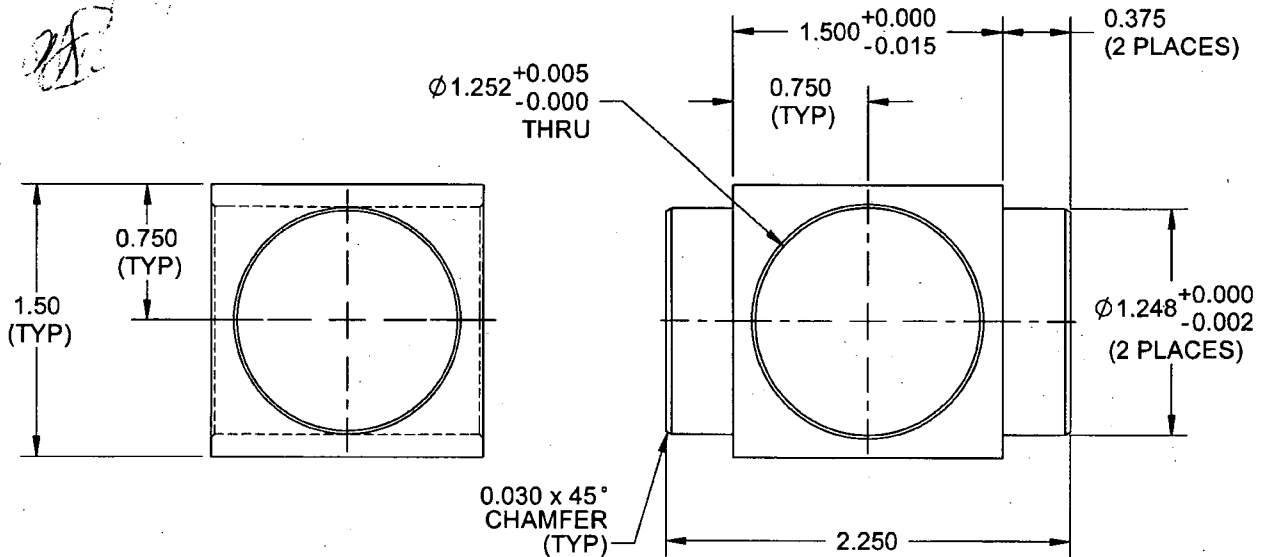
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NOTE: Date & initial all entries

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 8 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
04/33/09**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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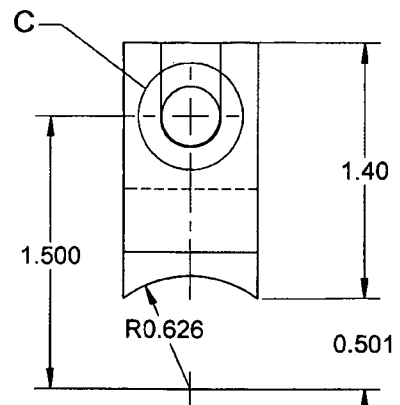
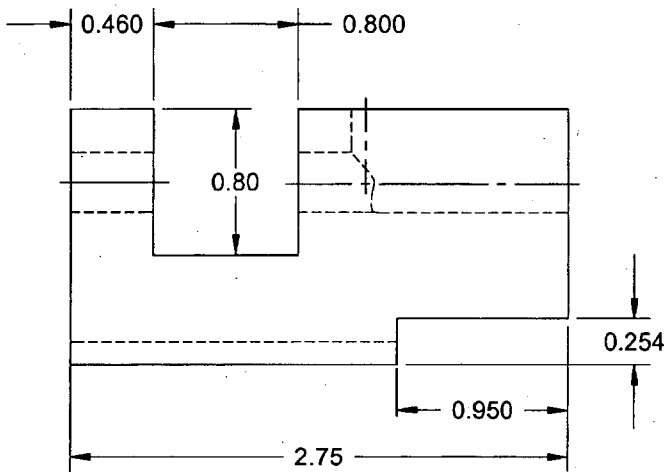
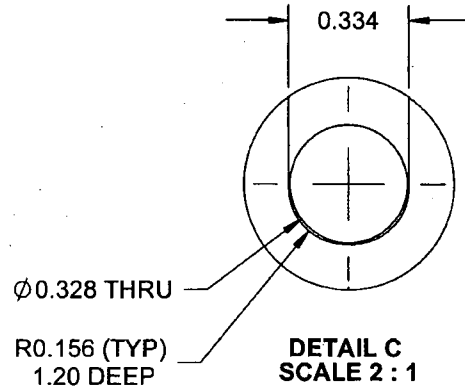
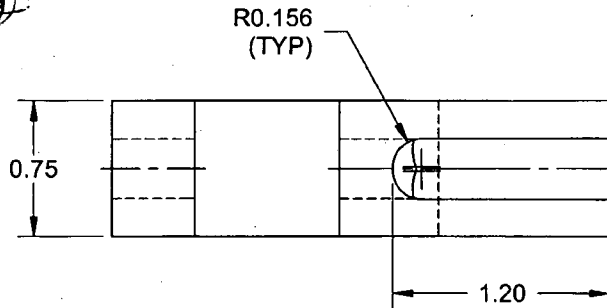
NOTE: Date & initial all entries

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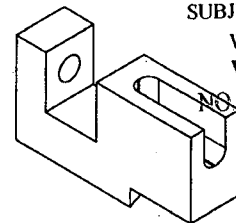
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 9 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
36/03/09

[Signature]

**D3353-15 LOCK BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:2

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

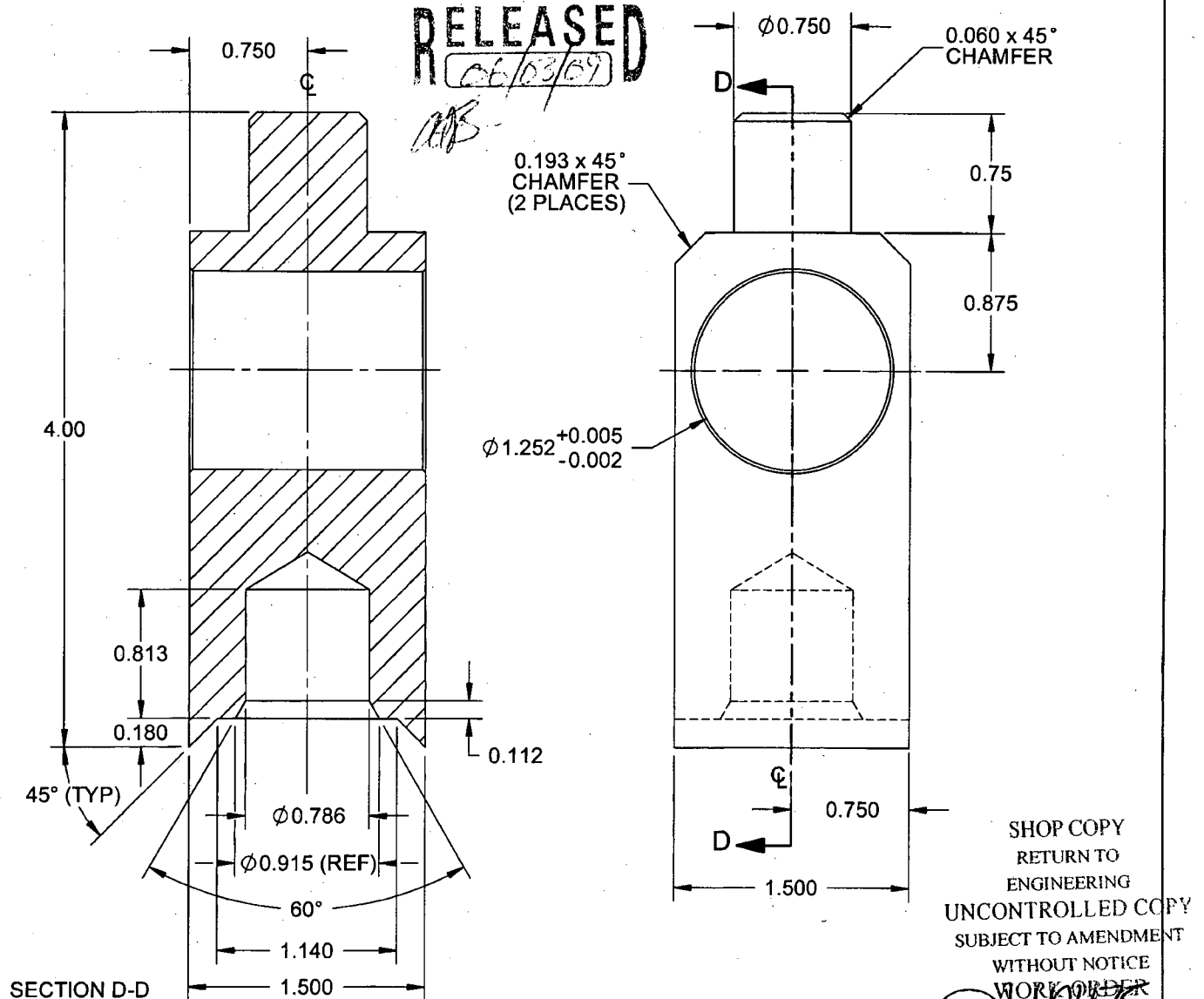
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3353	REV. A
DATE 04.12.14		TITLE LUG WELDMENT	SHEET 10 OF 10 SCALE 1:1

**D3353-17 SUPPORT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries